

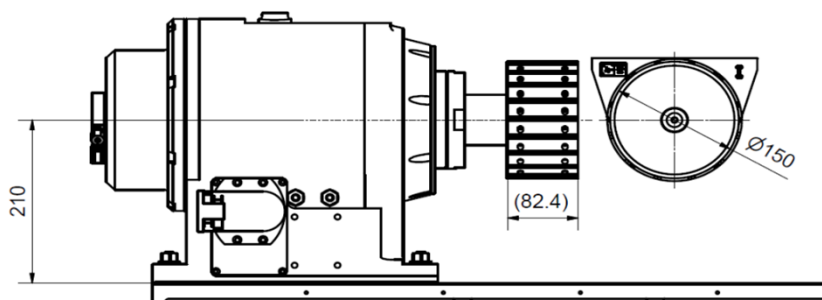
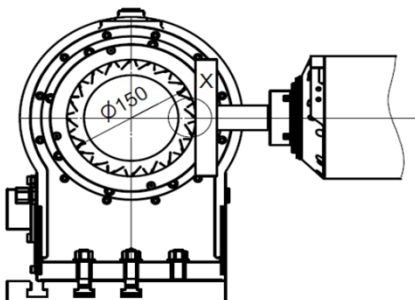
Planar Head Carbide Knife

A09-090

Width blank size 6mm, final knife size 5.5mm, material removal per side 0.25mm.

Process philosophy: two passes, one roughing and one finishing with a double-layer wheel, form 6A2.

Roughing grain on the inside diameter, finishing grain on the outer diameter.









1. Cycletime for Production

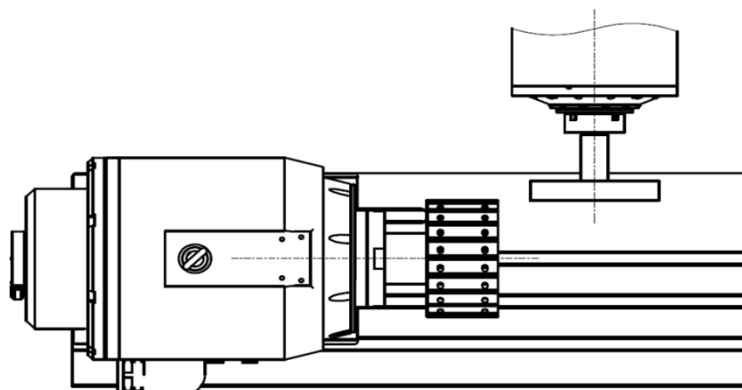
Workpiece:

Length 82.4 mm, Width 5.5 mm, Thickness 1.1 mm

Material carbide

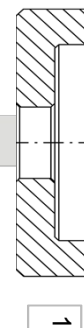
| Operations |  |  |  |  |
|---------------------|---|---|---|---|
| | Rough Clr | Finish Clr | Manual Handling | Sticking |
| Feed [mm/Min] | 600 | 600 | | 400 |
| Power [kW] | 4 | 2 | | 1 |
| Cutting speed [m/s] | 22 | 22 | | 22 |
| Used wheels |  |  | | |
| Grinding time [s] | 17 | 17 | 3 | 1 |
| Total cycle time | 00:38 | | | |

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.



2. Used Grinding Wheels

| | |
|---|---------------------|
| 1 | 6A2 Ø150 D126 / D46 |
|---|---------------------|



3. Machine and Software Requirements

Machines: **norma NGC**

Control: Fanuc 35i

Accessories: Multiposition Clamping

Responsible engineer: MAM, 13.01.16

Coolant: Emulsion, pressure 11 bar

Software: Quinto 5

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